

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004929**Date Inspected:** 08-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lui Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe fabrication and perform random inspections Orthotropic Box Girder components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Sub Assembly Bay 7:

Caltrans QA was requested to perform MT and VT verification of 64 Corner Assemblies for lift 5 and 6. QA performed MT and Visual of 4 corner assemblies. Corner assembly CA030 (welds 95, 96, 99, 134) was visually rejected by QA for Base metal gouge 30 mm in length and 4 mm deep. CA017 weld 083 was rejected by QA for a 3 mm crack. Areas were shown to ZPMC QC Shen Xue Hun. Mr. Shen stated that a CWR would be issued for the crack and that ZPMC QC would reinspect the remainder of corner assemblies prior to CT inspection.

Sub Assembly Bay 4:

Caltrans QA performed MT of the following

OBG

DP665-001 welds 1-6 (accepted)

DP666-001 welds 1-6 (accepted)

Tower

Caltrans QA performed MT verification of ZPMC tested and accepted South Tower Diaphragm welds

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

SSD1-SA361 welds 1, 2, 3, 4, 15 and 16. Green tagging documentation was not performed. ZPMC personnel were in process of thermal cutting of diaphragm bevels. See MT report TL-6038, generated on this date for further information.

Sub Assembly Bay 7:

Caltrans QA performed MT of the following

FB039-002 A side welds (accepted)

FB023-003 A side welds (accepted)

No other activities were monitored or performed this date.

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Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann 150 0219 9593, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Wright,Mark	QA Reviewer
